

DEPARTMENT OF TRANSPORTATION

DIVISION OF ENGINEERING SERVICES

Office of Structural Materials

Quality Assurance and Source Inspection



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Contract #: 04-0120F4Cty: SF/ALA Rte: 80 PM: 13.2/13.9File #: 69.28**WELDING INSPECTION REPORT****Resident Engineer:**Pursell, Gary**Address:** 333 Burma Road**City:** Oakland, CA 94607**Report No:** WIR-012756**Date Inspected:** 17-Mar-2010**Project Name:** SAS Superstructure**OSM Arrival Time:** 700**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 1900**Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island **Location:** Shanghai, China**CWI Name:** Li Yang, Wu Chi Cheng**CWI Present:** Yes No**Inspected CWI report:** Yes No N/A**Rod Oven in Use:** Yes No N/A**Electrode to specification:** Yes No N/A**Weld Procedures Followed:** Yes No N/A**Qualified Welders:** Yes No N/A**Verified Joint Fit-up:** Yes No N/A**Approved Drawings:** Yes No N/A**Approved WPS:** Yes No N/A**Delayed / Cancelled:** Yes No N/A**Bridge No:** 34-0006**Component:** Orthotropic Box Girder(OBG)**Summary of Items Observed:**

On this day CALTRANS OSM Quality Assurance (QA) Inspector Manoj Prabhune was present during the times noted above for observations relative to the fabrication of the SAS Superstructure being performed by Zhenhua Port Machinery Company (ZPMC) at Changxing Island in Shanghai, China. QA observed and/or found the following:

OBG # TRIAL ASSEMBLY YARD

Segment#6CW-PP47

This QA Inspector performed Inspection along with Mr.Manikandan for the Deck Panel Diaphragm offset at every alternative U - Ribs for Segment 6CW at Panel Point (PP) 47 and Segment 6AW at Panel Point (PP) 37 from North towards South side. The measured readings were recorded generated the report and submitted to the Task Leader and Engineer for review.

This QA Inspector randomly observed the following work in progress:

Segment # 7CE

Repair Welding.

This QA inspector observed, ZPMC qualified welding personnel identified as 058087 perform Shielded Metal Arc Welding (SMAW), weld joint identified as CA040-004; The Critical Welding Repair Report (CWRR) was B-CWR1227. ZPMC QC is identified as Mr. Tang Ya Jun. The welding parameters measured using QC's calibrated instrument appeared to be in general compliance with WPS-345-SMAW-2G (2F)-FCM-Repair-1.

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Segment# 7AW-7BW

This QA inspector observed, ZPMC qualified welding personnel identified as 045221 perform Shielded Metal Arc Welding (SMAW), weld joint identified as OBW7-005; ZPMC CWI is identified as Mr. Wu Chi Cheng. The welding parameters measured using QC's calibrated instrument appeared to be in general compliance with WPS-B-T-2214-B-U2-FCM-1

Segment# 7BW-PP52

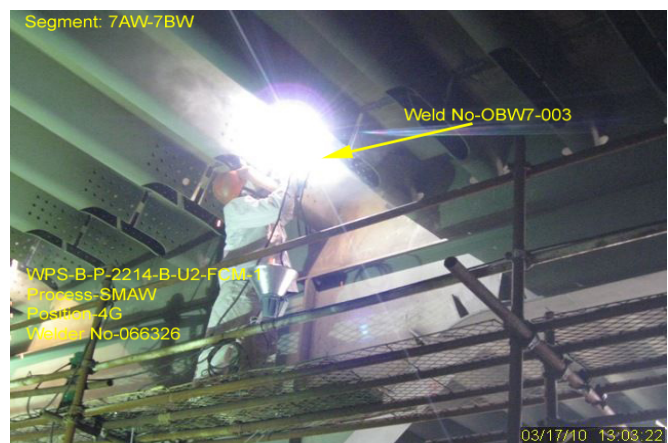
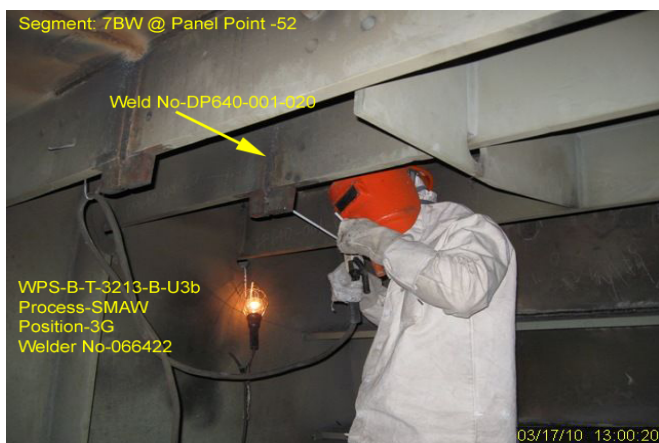
This QA inspector observed, ZPMC qualified welding personnel identified as 066422 perform Shielded Metal Arc Welding (SMAW), weld joint identified as DP640-001-020; ZPMC CWI is identified as Mr.Feng Ya Jun The welding parameters measured using QC's calibrated instrument appeared to be in general compliance with WPS-B-T-3213-B-U3b. See the attached below Photo.

Segment# 7AW-7BW

This QA inspector observed, ZPMC qualified welding personnel identified as 066326 perform Shielded Metal Arc Welding (SMAW), weld joint identified as OBW7-003; ZPMC QC is identified as Mr.Feng Ya Jun. The welding parameters measured using QC's calibrated instrument appeared to be in general compliance with WPS-B-T-2214-B-U2-FCM-1. See the attached below Photo.

Segment# 7AW-7BW

This QA inspector observed, ZPMC qualified welding personnel identified as 066361 perform Shielded Metal Arc Welding (SMAW), weld joint identified as OBW7-004; ZPMC QC is identified as Mr.Feng Ya Jun. The welding parameters measured using QC's calibrated instrument appeared to be in general compliance with WPS-B-T-2214-B-U2-FCM-1.



Summary of Conversations:

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Only general conversation was held between QA and QC concerning this project.

Comments

This report is for the purpose of determining conformance with the contract documents and is not for the purpose of making repair or fit for purpose recommendations. Should you require recommendations concerning repairs or remedial efforts please contact Eric Tsang phone: 15000422372, who represents the Office of Structural Materials for your project.

Inspected By:	Prabhune,Manoj	Quality Assurance Inspector
Reviewed By:	Miller,Mark	QA Reviewer
